

Work Order ID 63694

November 10, 2010 9:09:14 AM



Page 1

Item ID: D4211-045

Accept



Setup

Start



Revision ID:

Item Name: Wearplate, Aft

Stop



Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4211	B

100



Waterjet

FLOW CNC Waterjet

304 .063

Memo

0.00

KB 10-11-11

1-Cut as per Dwg ***Make from D4211-5F***

Dwg Rev:

Prog Rev:

2-Deburr if necessary

10

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

KB 10-11-11

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63694

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Page 2

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Item Name: Wearplate, Aft

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Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

S. Solulay

10

130



Brake NC

Brake NC

Form as per dwg

0.00

SB 10/10/17

10

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Solulay

10

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 63694

November 10, 2010 9:09:15 AM



Page 3

Item ID: D4211-045

Accept



Setup Start



Revision ID:

Item Name: Wearplate, Aft

Stop



Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

150



Large Fab

AT9696

10.11.23

Memo

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

QC10

10/11/23

Memo

0.00

0.00

S.10/11/23

Phu >

165



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S.10/11/23

(X10)
-45>

W/O: 63694

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/23	# 160	Perm. change Change to a action. to have consistency with 74 other wear plates		10/11/23			10/11/23

Part No: D41211-045 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 63694

November 10, 2010 9:09:15 AM



Page 4

Item ID: D4211-045

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Setup

Start



Revision ID:

Item Name: Wearplate, Aft

Stop



Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

170



Powdercoat

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M112588

Set Up/
Run Hours

0.00

Tool ID

1011124

Tool #

Plan
Code

10

Accept
Qty

10

Reject
Qty

0

Reject
Number

10

Insp.
Stamp

10

Powder Coating

Memo

Start Time: 9:30 AM
Oven Temperature: 320°C
Finish Time: 10:00 AM

0.00

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10/11/2010 SP 10x

190



Packaging

Packaging

Identify as per dwg & Stock Location: 137

0.00

Memo

0.00

10/11/2010 SP 10x

W/O:		WORK ORDER CHANGES					
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Work Order ID 63694



Page 5

November 10, 2010 9:09:16 AM

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Setup Start



Revision ID:

Item Name: Wearplate, Aft

Stop



Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

200



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/11/25 JF

Memo

0.00

MF
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 9:09:13 AM

Page 1

Work Order ID: 63694



Parent Item: D4211-045



Parent Item Name: Wearplate, Aft

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	170.6000	0.1366	1.437895			

304/316 Sheet .063



B.10-11-11

Location	Loc Qty	Loc Code
MAT	170.6	
111323	0	
115688	10.6	
115953	160	

115688

10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63694
Description: WEAR PLATE AM	Part Number:	D4211-5
Inspection Dwg: Rev: B		Page 1 of 1

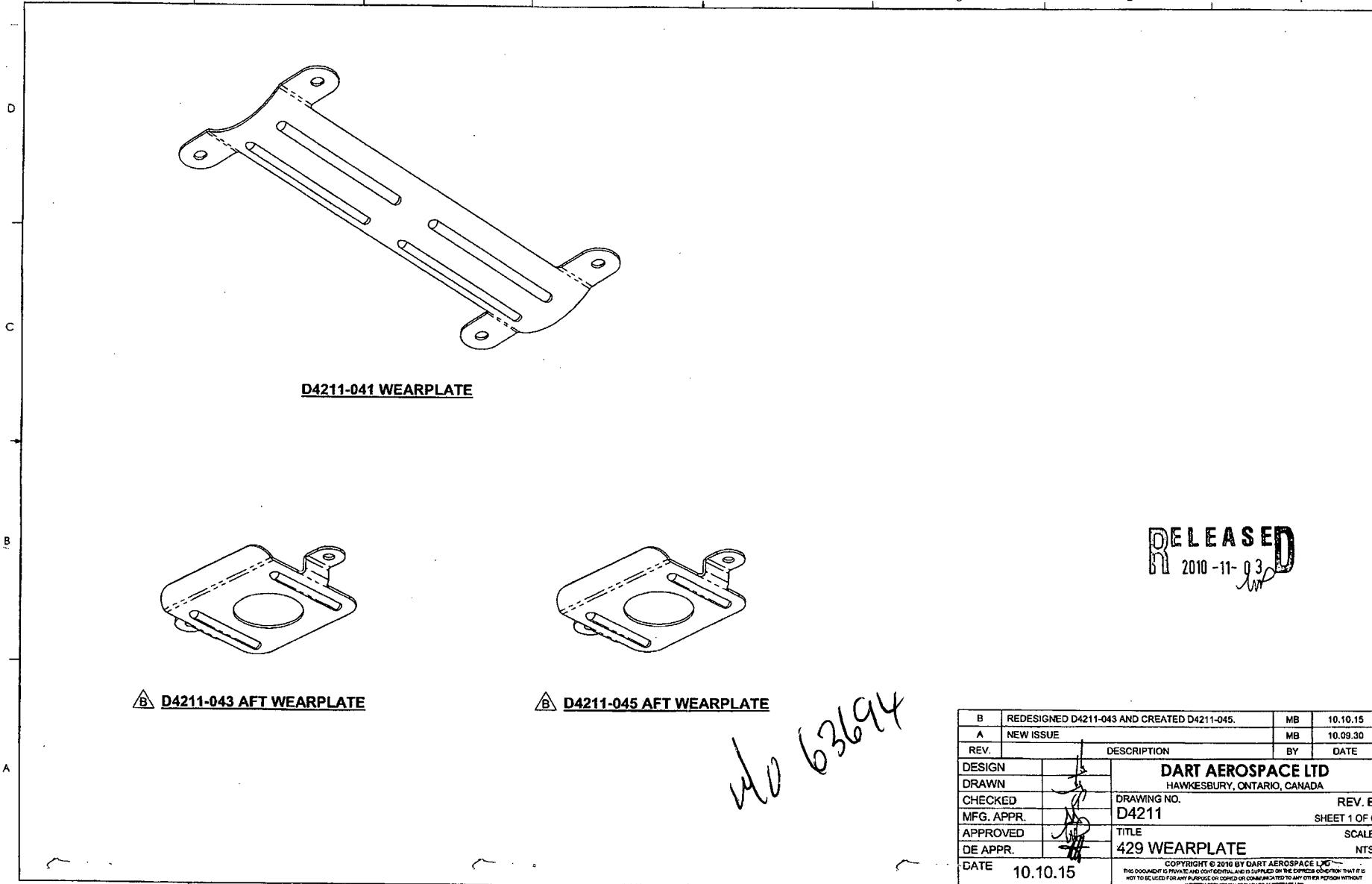
FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>KB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-11-11</u>	Date: <u>10/11/11</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



W0 63694

B	REDESIGNED D4211-043 AND CREATED D4211-045.	MB	10.10.15
A	NEW ISSUE	MB	10.09.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO. REV. B		
MFG. APPR.	D4211 SHEET 1 OF 6		
APPROVED	TITLE SCALE		
DE APPR.	429 WEARPLATE NTS		
DATE	10.10.15		

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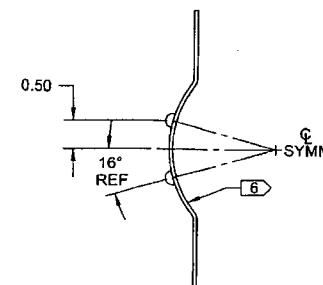
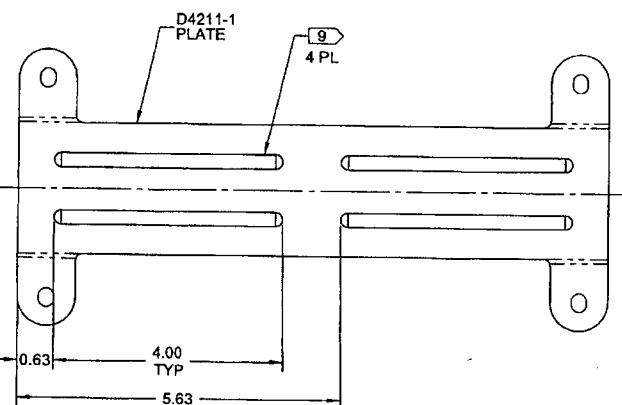
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

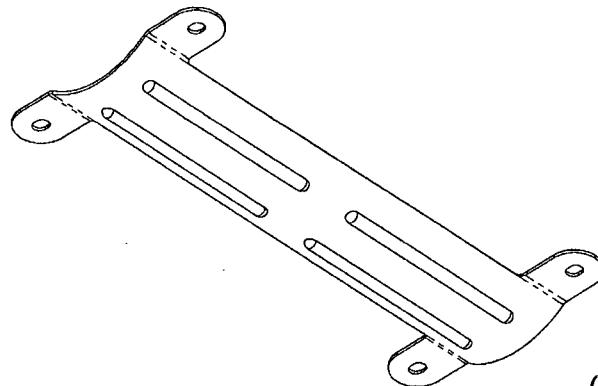
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
X	041	D4211-041	WEARPLATE
1	1	D4211-1	PLATE
2	AVR	2059B	HARDCOAT



D4211-041 WEARPLATE



RELEASED
R 2010-11-03
63694

D4211-041 NOTES:
 1) MATERIAL: NONE
 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-041" AND B/N "BXXXXX" PER DART QSI 044 6.1
 7) WEIGHT: 0.64 lbs
 8) WELDING: PER DART QSI 004
 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PP</i>	DRAWING NO.	
MFG. APPR.	<i>M</i>	REV. B	
APPROVED	<i>MP</i>	D4211	
DE APPR.	<i>MP</i>	SHEET 2 OF 6	
DATE	10.10.15	TITLE	429 WEARPLATE
		SCALE	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

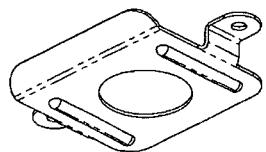
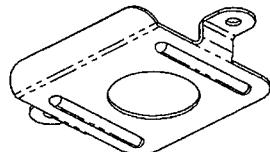
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

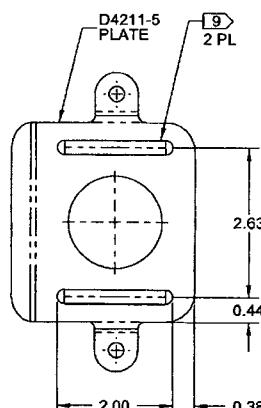
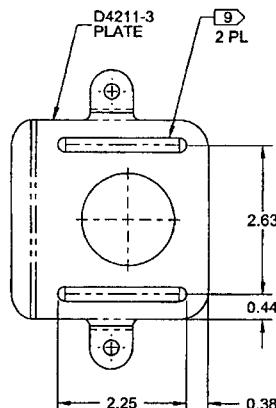
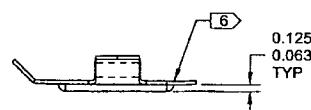
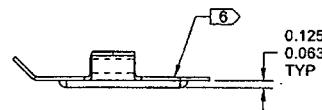
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NOTE: Date & initial all entries

8 1 7 6 5 4 3 2 1



ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X	X	D4211-043	AFT WEARPLATE
			D4211-045	AFT WEARPLATE
1	1	1	D4211-3	PLATE
2		1	D4211-5	PLATE
3	A/R	A/R	2059B	HARDCOAT



A D4211-043 AFT WEARPLATE

A D4211-045 AFT WEARPLATE

D4211-043/-045 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-04X" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

8 7 6 5 4 3 2 1

DESIGN	<i>1a</i>	DART AEROSPACE LTD	
DRAWN	<i>1b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1c</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>1d</i>	D4211	SHEET 3 OF 6
APPROVED	<i>1e</i>	TITLE	SCALE
DE APPR.	<i>1f</i>	429 WEARPLATE	NTS
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63644
RELEASED
2010-11-03
1b

8 7 6 5 4 3 2 1

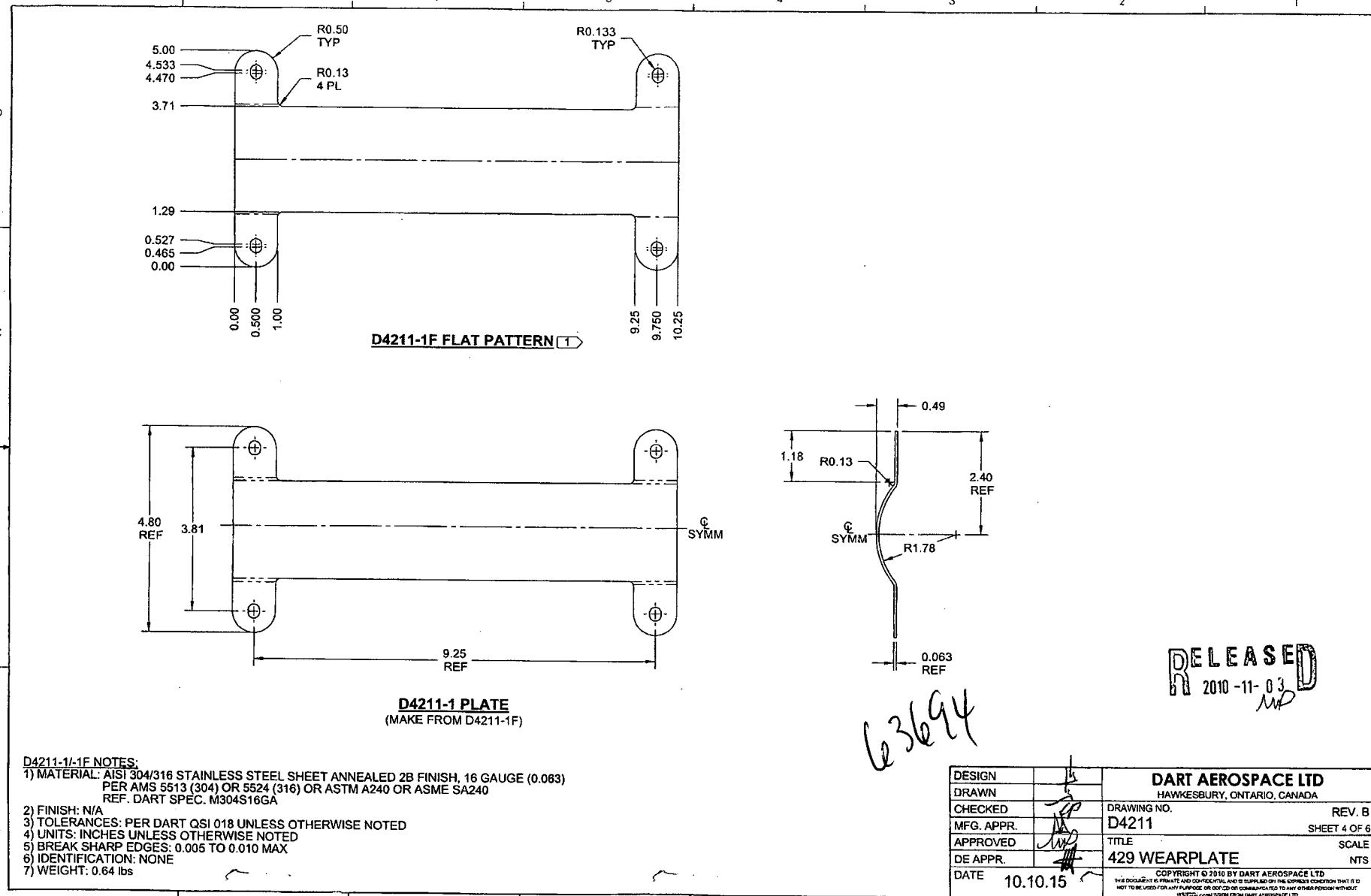
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MFG. APPR.		D4211	SHEET 4 OF 6
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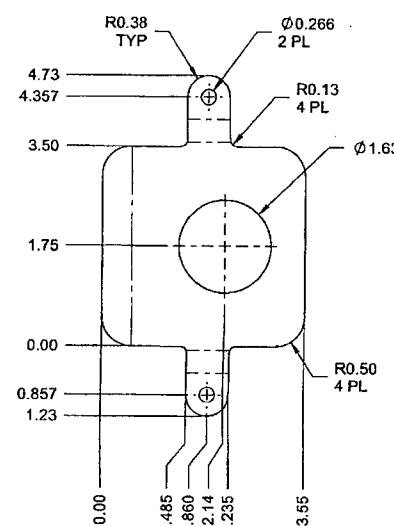
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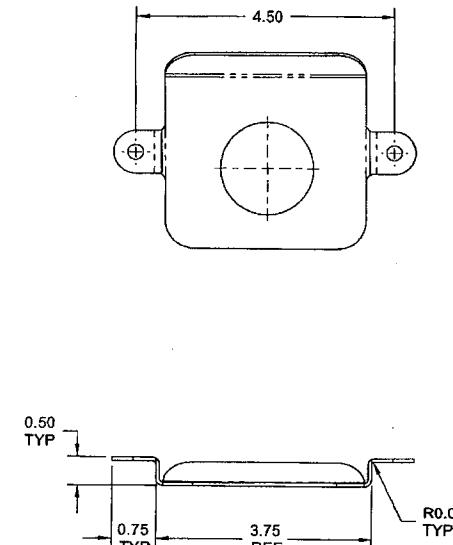
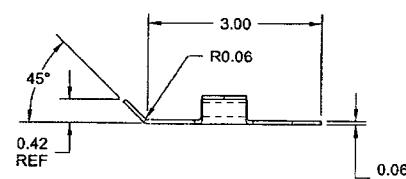
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D4211-3F FLAT PATTERN



D4211-3 PLATE
 (MAKE FROM D4211-3F)

63694

RELEASE
2010-11-03

D4211-3/3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs

DESIGN		DART AEROSPACE LTD
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MFG. APPR.		REV. B
APPROVED		D4211
DE APPR.		SHEET 5 OF 6
DATE	10.10.15	TITLE
		429 WEARPLATE
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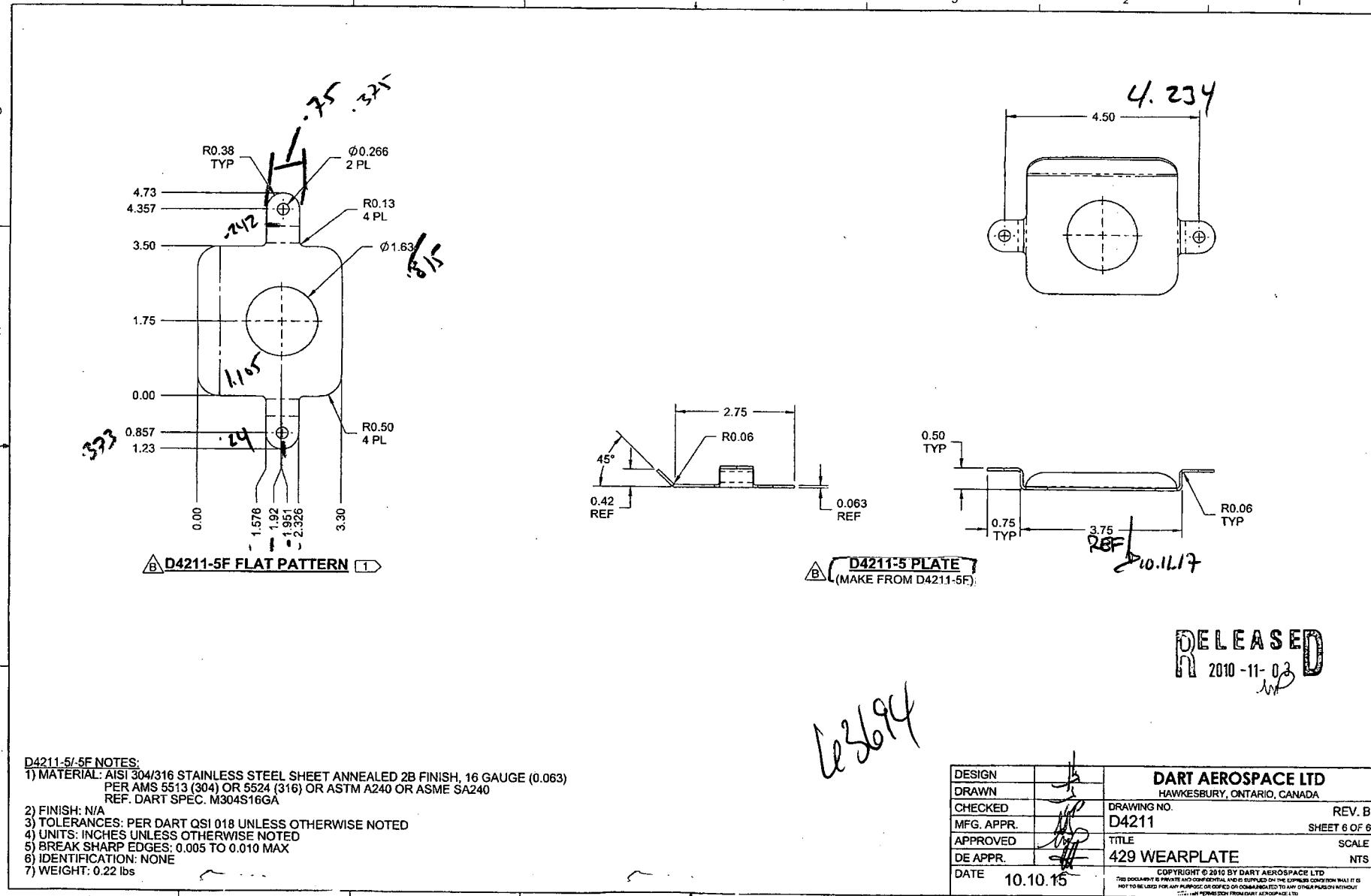
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DESIGN	<i>15</i>	DART AEROSPACE LTD	
DRAWN	<i>15</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>15</i>	DRAWING NO.	<i>D4211</i>
MFG. APPR.	<i>15</i>	REV. B	SHEET 6 OF 6
APPROVED	<i>15</i>	TITLE	429 WEARPLATE
DE APPR.	<i>15</i>	SCALE	NTS
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